

# Work Order ID 103852

**\*103852\***

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July-03-13 9:28:07 AM

Item ID: D2565-207 Accept **\*N9000040100\*** Setup Start **\*NS1\***  
 Revision ID: **DAS 27** Stop **\*NS2\***  
 Item Name: Strut  
 Start Date: 7/03/13 Start Qty: 5.00 **\*5\*** Cust Item ID:  
 Required Date: 7/16/13 Req'd Qty: 5.00 **\*5\*** Customer:  
 Reference:

Approvals: Process Plan: *[Signature]* Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2565	Rev E

100	Punch ends and deburr as per dwg	0.00							
<b>*100*</b>	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	Punch as per Dwg D2565 using DT 8313								

110	Small Fab	0.00							
<b>*110*</b>									
Small Fab	Memo	0.00							
Small Fab	Deburr								

120	QC5- Inspect part completeness to step on W/O	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

*[Signature]*  
13/07/104

*S*

*Sx*

*[Signature]*  
13/07/12

**DAS 27**

*B7 12*

*S*

**\*103852\***

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**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 7/03/13      **Start Qty:** 5.00      **\*5\***

**Cust Item ID:**

**Required Date:** 7/16/13      **Req'd Qty:** 5.00      **\*5\***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

**\*130\***

Powdercoat

## Powder Coating

## Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

140

### QC3- Inspect Part Finish

0.00

**\*140\***

QC

## Quality Control

## Memo

0.00

150

Identify as per dwg & Stock Location: ST253A 0.00

0.00

**\*150\***

## Packaging

## Packaging

## Memo

0.00

Sx  $\phi$  m-f 13/07/12

5 6 12 13-7-12

5x 11.10.13-07-15

# Picklist Print

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Work Order ID: 103852

Parent Item: D2565-207

Parent Item Name: Strut

Start Date: 7/03/13

Required Date: 7/16/13

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP: D01.08.28Added Powder coat, and added Inspection level 3 and 21.SM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	838.2989	1.7916	9.4294737			
304 RD Tube .750 x .049W													
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				MAT017		838.2988825							
				122312		13.3							
				122468		0.0000325							
				124768		83.93245							
				125068		52.0664							
				125513		289							
				M126183		400							

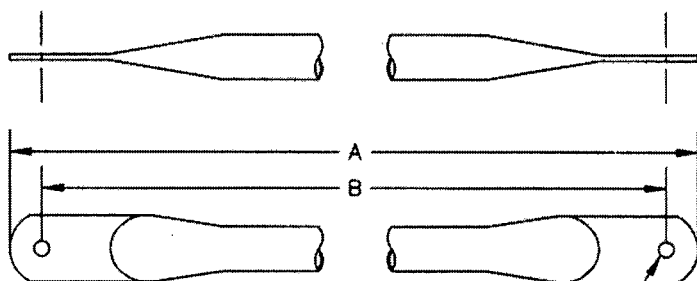
SB 03/07/04

10-5



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT	SCALE 1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

RELEASED  
04 05 05



DIA 0.257 TO BE PUNCHED  
"C" DIA TO BE OPENED MANUALLY  
PUNCH ENDS PER SPEC CONTROL DRAWING D2638

*Handwritten signature*

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

#### GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL  
(REF DART SPEC. M304TR0.750W0.049)  
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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